

Work Order ID 106971

September-12-13 8:12:58 AM

106971

Page 1

Item ID: D4822-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Right Deflector

Start Date: 9/12/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4822	REV A
-------	-------

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

Bandsaw

Memo

Jeaspa Bandsaw

CUT AT 32.00" LONG

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

Outsource5

Memo

Outsource process - Machining

ISSUE P/O: 21415
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

115

Packaging

Memo

Packaging

0.00

11309-12

2 0

C2 13/09/19 (2)

P13/14/17 (2)

Work Order ID 106971

106971

Page 2

September-12-13 8:12:58 AM

Item ID: D4822-2

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N900040100

Setup Start *NS1*

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Item Name: Upper Right Deflector

Start Date: 9/12/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

117

QC6- Inspect dimensions to drawing

0.00

117

QC

Memo

0.00

DAS

27

9-89

Quality Control

13/10/19

118

0.00

118

HandFinish

Memo

0.00

Hand Finishing

REMOVE ALL PART MARKINGS

N/A

Q2 13/10/18

120

0.00

120

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE IAW MIL-A-8625 TYPE 3
COLOUR BLACK

PRIME AS PER DWG NOTE #2

P/O: 21743

Q2 13/10/18 (2)

125 →

sent

13/10/18 (2)

Work Order ID 106971

September-12-13 8:12:58 AM

106971

Page 3

Item ID: D4822-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Right Deflector

Start Date: 9/12/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
122 *122* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00							
				<i>n/a</i>					
				<i>SMB</i>					
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>2</i>			
				<i>DAS 27 9-89</i>					
				<i>13 10 28</i>					
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
				<i>SM139F</i>					
						<i>13/14/29</i>	<i>2</i>		
								<i>DAS 32 9-89</i>	

Work Order ID 106971

106971

Page 4

September-12-13 8:12:58 AM

Item ID: D4822-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Right Deflector

Start Date: 9/12/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

[Signature] *Rm* 13/10/29

me
13-10-29

Picklist Print

September-12-13 8:12:58 AM

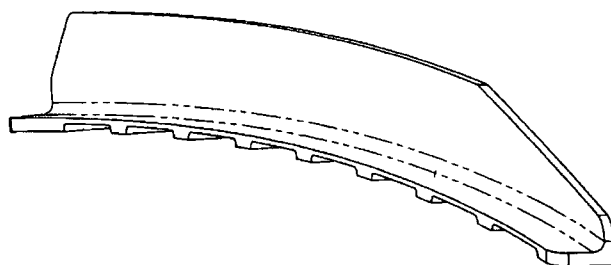
Page 1 / 1

Work Order ID: 106971
 Parent Item: D4822-2
 Parent Item Name: Upper Right Deflector

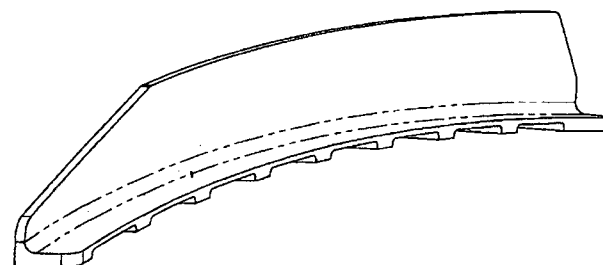
Start Date: 9/12/13 Required Date: 9/24/13
 Start Qty: 2.00 Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4822-2P		Purchased	No				Each	0.0000		2			
Upper Right Deflector													
M7075T73B4.000x4.000		Purchased	No				f	16.9600		5.6842105			
7075-T73 Bar 4.0 x 4.0										5.375			



D4822-2 UPPER DEFLECTOR RH

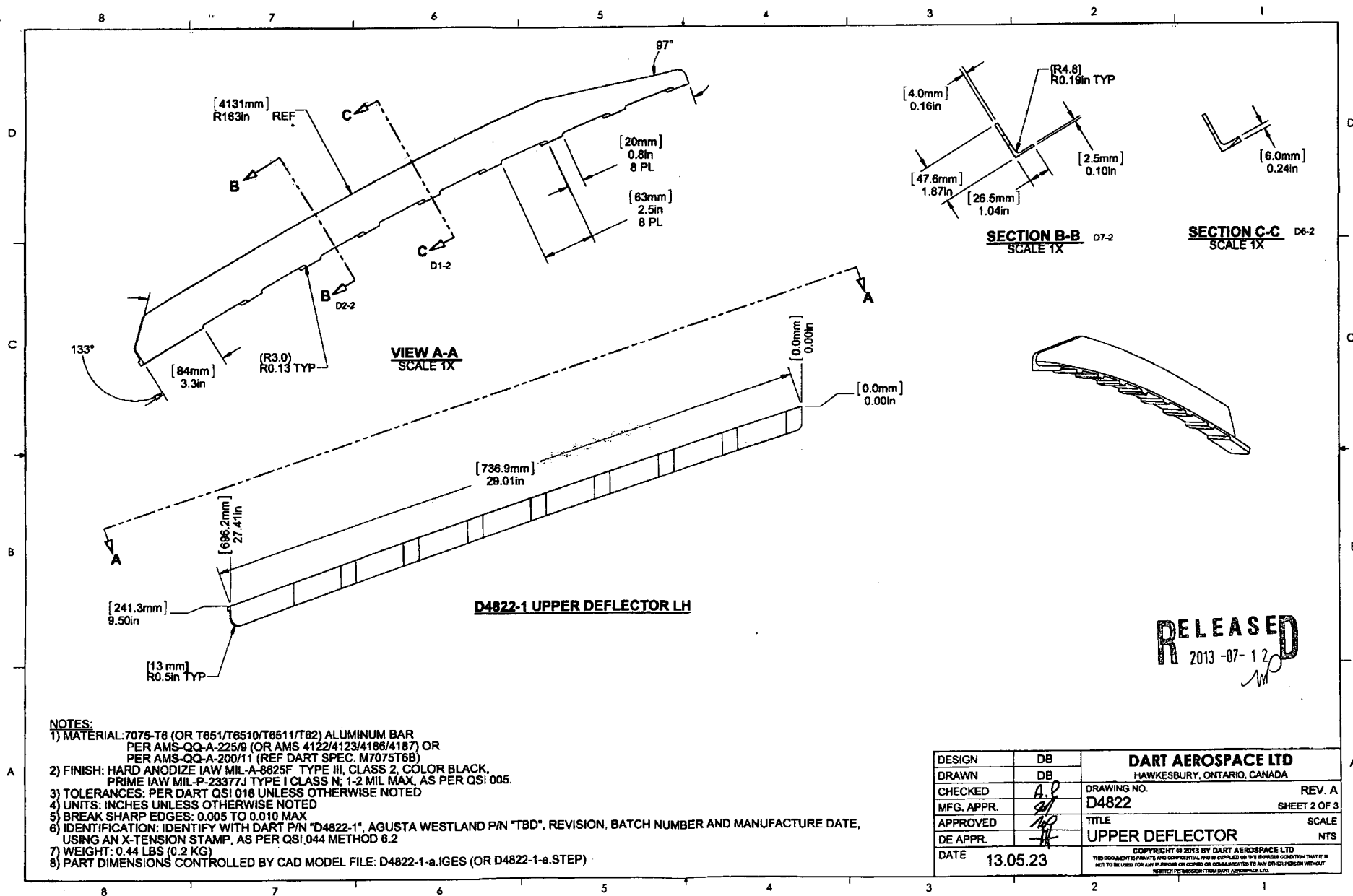


D4822-1 UPPER DEFLECTOR LH

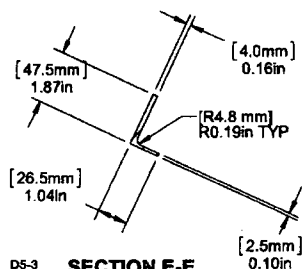
RELEASED
2013-07-12
WP

*also
106971*

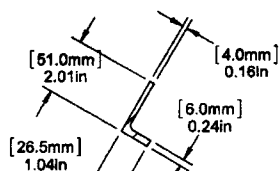
A		NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD		REV. A	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3	
CHECKED	<i>A.P.</i>	DRAWING NO. D4822		SCALE	
MFG. APPR.	<i>[Signature]</i>	TITLE UPPER DEFLECTOR		NTS	
APPROVED	<i>[Signature]</i>	DATE 13.05.23			
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



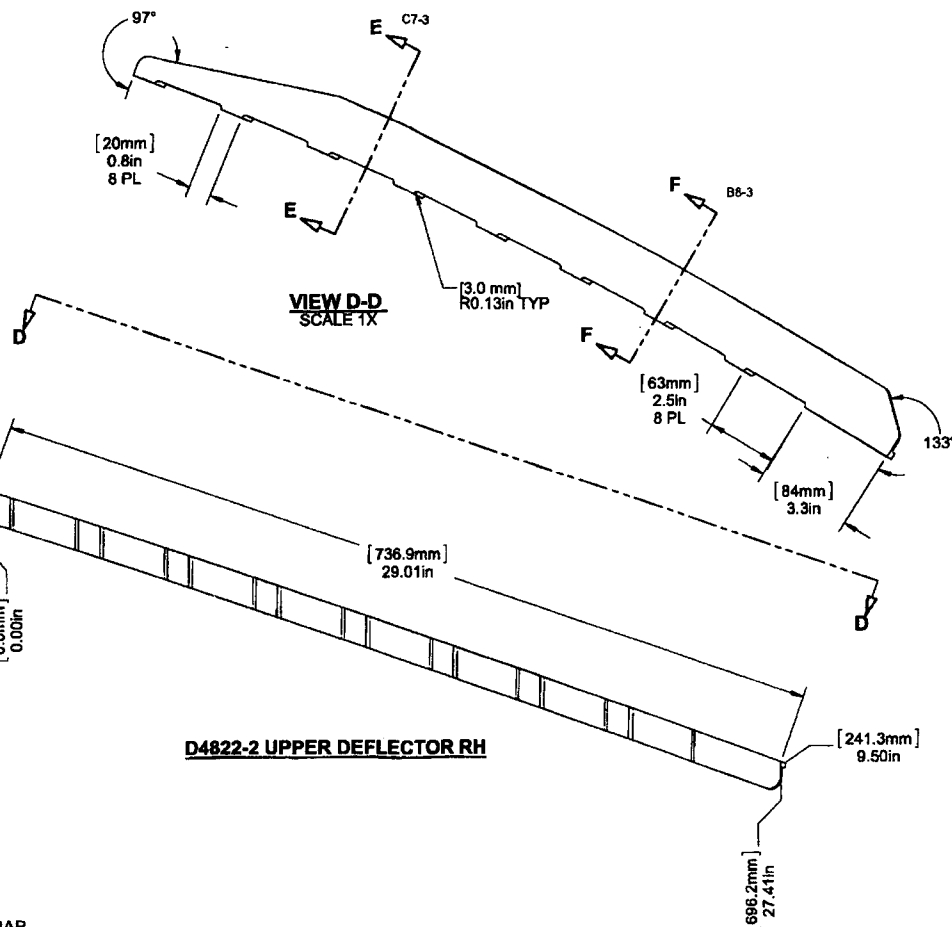
8 7 6 5 4 3 2 1



SECTION E-E
SCALE 1X



SECTION F-F
SCALE 1X



D4822-2 UPPER DEFLECTOR RH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC. M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8825F TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N'D4822-2', AGUSTA WESTLAND P/N 'TBD', REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.44 LBS (0.2 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-2-a.IGES (D4822-2-a.STEP)

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4822	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPPER DEFLECTOR	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHERS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-07-12

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO21415**

Purchase Order Date 9/19/2013

PO Print Date 9/19/2013

Page Number 1 of 1

Order From : VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms

Currency

FOB

Chantal Lavoie

COD

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4822-1P AS PER DWG D4822 REV. A B106972	Upper Deflector, RH	10/4/2013 10/4/2013 Yes		2.00 Each	\$1,785.00	\$3,570.00
Line Total:							\$3,570.00
2	D4822-2P AS PER DWG D4822 REV. A B106971	Upper Right Deflector	10/4/2013 10/4/2013 Yes		2.00 Each	\$1,785.00	\$3,570.00
Line Total:							\$3,570.00
PO Total:							\$7,140.00

u cl

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

PST# 6122-5207

Change Nbr:

1

Change Date: 9/19/2013



Packing Slip 36495

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N
 TEL: 613-384-1662 FAX: 613-384-295
 www.wejay.co

SOLD TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K7

SHIP TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1K7

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA							
		PC21415		09/20/13		Best way							
CUSTOMER CODE			PROV. LIC. NO.		Extra		Exempt						
					<input type="checkbox"/>		<input type="checkbox"/>						
QUANTITY ORDERED			B.O.			QUANTITY SHIPPED		DESCRIPTION		UNIT PRICE		AMOUNT	
—						2		Fabricate upper deflector, LH, as per drawing D4822, Rev. A Ref: D4822-1P ID: B106972					
—						2		Fabricate upper right deflector as per drawing D4822, Rev. A Ref: D4822-2P ID: B106971 					

ORDER: COMPLETE ☐
 PARTIAL ☐

TOTAL

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITH
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Oct 17, 2013	
		P.O.# PO21415	
		WEJAY JOB# 36495	
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-1P Upper Deflector, LEFT'	2	Machined complete per drawing req'ts	D4822 / rev. A
D4822-2P Upper Deflector, RIGHT'	2	Machined complete per drawing req'ts	D4822 / rev. A
Note: Material supplied by Dart Aerospace			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Oct 17, 2013	
		P.O.# PO21415	
		WEJAY JOB# 36495	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-1P Upper Deflector, LEFT'	2	Machined complete per drawing req'ts	D4822 / rev. A
D4822-2P Upper Deflector, RIGHT'	2	Machined complete per drawing req'ts	D4822 / rev. A
Note: Material supplied by Dart Aerospace			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36495

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO21415

PART No. D4822-2P

DESCRIPTION: Upper Deflector RH

DWG No. D4822

REV. A

E.C.O.

MATERIAL: Aluminium 7075 supplied by Dart Aerospace

INSPECTOR:

E.J.

QUANTITY
REC'D: 2

ACCEPT: 2

REJECT: -

N.C.R.# -

DATE: 10/16/2013

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1							
2	97 deg.	97.689 ^{on}	$\pm .5 \text{ deg.}$	View D-D	97.7 deg.		
3	0.8" x 8 places		$\pm .1"$.788 - .790		
4	2.5" x 8 places	2.460 ^{on}	$\pm .1"$		2.465 - 2.463		
5	R0.13" typ		$\pm .03"$		R.13"		
6	3.3"		$\pm .1"$		3.302"		
7	133 deg.		$\pm .5 \text{ deg.}$		133 deg.		
8	0.16"		$\pm .03"$	Section E-E	.158 - .160		
9	R0.19" typ.		$\pm .03"$		R.193		
10	.10"		$\pm .03"$.092 - .098		
11	1.04"		$\pm .03"$		1.046"		
12	1.87"		$\pm .03"$		1.865 - 1.863		
13			$\pm .03"$				
14	0.24"		$\pm .03"$	Section F-F	.232 - .236		
15	0.16"		$\pm .03"$.158 - .160		
16	2.01"		$\pm .03"$		2.003 - 2.005		
17	1.04"		$\pm .03"$		1.046		
18	R0.5 typ	R.393 ^{on}	$\pm .1"$	Main	R.405		
19	29.01"	29.258 ^{on}	$\pm .03"$		29.251"		
20	9.50"	9.281 ^{on}	$\pm .03"$		9.271"		
21	27.41"	27.746	$\pm .03"$		27.742"		
22							
23							
24							
25							
26							
27							
28							
29							
30							
31							
32							
33							
34							
35							
36							



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

36495

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO21415

PART No. D4822-1P

DESCRIPTION: Upper Deflector LH

DWG No. D4822

REV. A

E.C.O.

MATERIAL: Aluminium 7075 supplied by Dart Aerospace

INSPECTOR:

EJ.

QUANTITY
REC'D: 2

ACCEPT: 2

REJECT: -

N.C.R.# -

DATE: 10/16/2013

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	R163"			View A-A	R163		
2	97 deg.	97.689 deg	$\pm .5$ deg.		97.7 deg.	1	drawing and solid different
3	0.8" x 8 places		$\pm .1$ "		.775" - .790"	8	
4	2.5" x 8 places	2.460" ^{on solid}	$\pm .1$ "		2.465" - 2.470"	8	
5	R0.13" typ		$\pm .03$ "		R.13"	16	
6	3.3"		$\pm .1$ "		3.301"		
7	133 deg.		$\pm .5$ deg		133 deg.		
8	0.16"		$\pm .03$ "	Section B-B	.160 - .1625		
9	R0.19" typ.		$\pm .03$ "		R.193		
10	.10"		$\pm .03$ "		.100 - .111		
11	1.04"		$\pm .03$ "		1.045 - 1.047		
12	1.87"		$\pm .03$ "		1.87 - 1.877		
13	0.16"		$\pm .03$ "				
14	0.24"		$\pm .03$ "	Section C-C	.235 - .249		
15	29.01"	29.258" ^{on solid}	$\pm .03$ "	Main	29.252"		
16	27.4"	27.746" ^{on solid}	$\pm .1$ "		27.744"		
17	9.50"	9.281" ^{on solid}	$\pm .03$ "		9.273"		
18	R0.5"	R.393" ^{on solid}	$\pm .1$ "		R.405"		
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							
30							
31							
32							
33							
34							
35							
36							



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62704

Date: 25-Oct-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms

Ship Via

Quantity

Description

1
lot

Part: ASST

Rev:

2 PCS D4822-1 (28.50)

2 PCS D4822-2 (28.50)

HARD ANODIZE BLACK
MIL-A-8625 TYPE III CLASS 2

PRIME MIL-P-23377J TYPE I CLASS N

20 PCS D2348 (0.95)
BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2

PRICE IS PER PIECE
Job: 20130670

PO: 21743

Line:

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance
with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 25/10/13

CERTIFIED SIGNATURE: 

RECEIVER SIGNATURE: _____